

Work Order ID 50812

July 22, 2009 2:57:04 PM

Req'd latest 31/07



Page 1

Item ID: D2229

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 7/24/09

Start Qty: 24.00



Cust Item ID:

Required Date: 7/28/09

Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2229

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D2229
Deburr if necessary

Dwg Rev: B

Prog Rev: B

12-

HB 9-7-22

LB 09/07/22

34

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-7-22

34

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 80210763

counted
x34

φ

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Page 2

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Run Start



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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr. No sharp edges

u/a

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

09-07-23

34

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> 8 or 12/24

counter
x34

φ

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Page 3

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Item Name: Doubler

Start Date: 7/24/09

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Required Date: 7/28/09

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 21

0.00



Packaging

Memo

0.00

Packaging

Per 17/24 (34)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27

u 9.07.24

Picklist Print

July 22, 2009 2:57:03 PM

Page 1

Work Order ID: 50812

Parent Item: D2229RevB

Parent Item Name: Doubler

Comments:

Start Date: 7/24/09

Required Date: 7/28/09

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	158.6888	1.3162			



2024-T3 .063 sheet



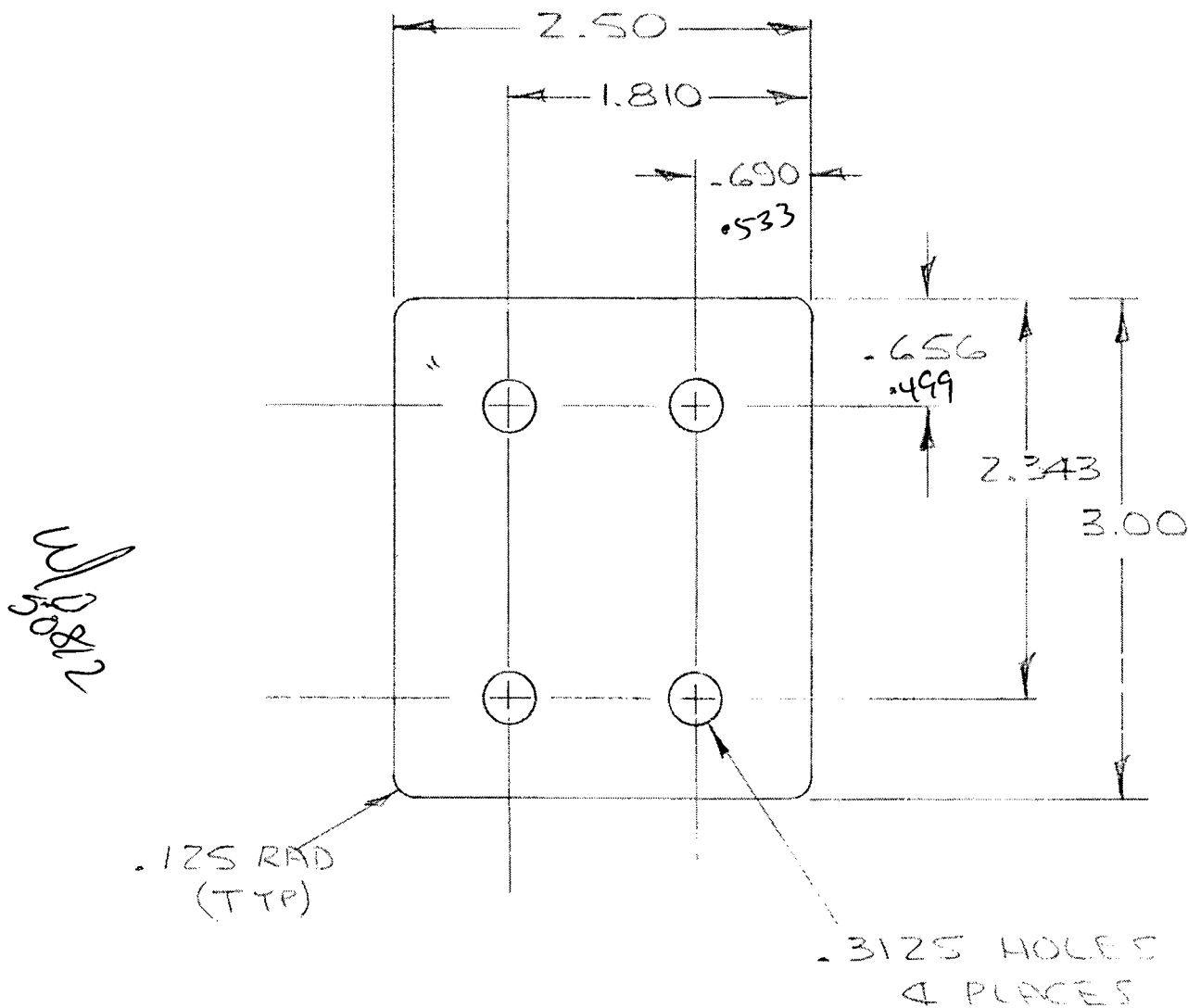
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	158.6888421	
102942	1.5	
105916	3.69	
106223	1.47	
109463	24.2	
110980	15.45	
111787	110.378842	
19059	2	

111787 139-7-22



DRAWN BRADLEY 94-3-28		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94-3-28	DRAWING NO D2229	REV B	SHEET 1 OF 1
		TITLE DOUBLER	

A	NEW ISSUE	94/3/28	4/
B	ALODINE W/ ANODIZE	97/11/86	5



MATERIAL: 2014-T3 ALUMINUM
.063 THICK

FINISH: ALODINE PER NASI 005-4.1